

slip May 1

Dart Aerospace Ltd.

Date: Tuesday, 28/04/2009 10:02:05 AM  
User: Linda Lacelle

# Process Sheet

<b>Customer</b> :	CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> :	GUSSET ASS'Y
<b>Job Number</b> :	47558		
<b>Estimate Number</b> :	13866		
<b>P.O. Number</b> :		<b>Part Number</b> :	D3929042
<b>This Issue</b> :	28/04/2009	<b>S.O. No.</b> :	
<b>Prsht Rev.</b> :	NC	<b>Drawing Number</b> :	D3929 REV A
<b>First Issue</b> :	/ /	<b>Project Number</b> :	N/A
<b>Previous Run</b> :	47274	<b>Drawing Revision</b> :	A
		<b>Material</b> :	
<b>Written By</b> :		<b>Due Date</b> :	01/05/2009
<b>Checked &amp; Approved By</b> :		<b>Qty:</b>	10
<b>Comment</b> :	Est Rev:A 09-04-20 new issue EC verified by:DD		
		<b>Um:</b>	Each

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	M304S11GA	304/316 0.125 Sheet
-----	-----------	---------------------



**Comment:** Qty.: 0.4725 sf(s)/Unit Total : 4.7250 sf(s)  
304/316 .125" Sheet  
Batch: 111018 B 9-4-28

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------



**Comment:** FLOW WATER JET  
1-Cut as per Dwg D3929  
Dwg Rev: A  
Prog Rev: A

B 9-4-28



2-Deburr if necessary B 9-4-28

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

B 9-4-28

4.0	QC8	SECOND CHECK
-----	-----	--------------



**Comment:** SECOND CHECK

S 09/04/28 (10)

5.0	D39071	Bushing
-----	--------	---------



**Comment:** Qty.: 2.0000 Each(s)/Unit Total : 20.0000 Each(s)  
Bushing  
Batch: B47105 ->3 B47556 ->17

PD 09-04-29

Date: Tuesday, 28/04/2009 10:02:05 AM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: GUSSET ASS'Y

Job Number: 47558

Part Number: D3929042

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Weld bushings D3907-1 as per dwg D3929

316L rod batch: H108160

PD 09-04-29 (10)

7.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

Cpl 09-04-30

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 02/04/30 (10)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify as per dwg and Stock

Location: \_\_\_\_\_

PPP 47636

SS 09/04/30 (10)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/04/30

Job Completion




MF 09-04-30

DART AEROSPACE LTD		Work Order:	47558
Description: GUSSET ASSY		Part Number:	D3929-0421
Inspection Dwg: D3929-0421 Rev: A		Page 1 of 1	

## FIRST ARTICLE INSPECTION CHECKLIST

☒ **First Article**      ☐ **Prototype**[illegible]

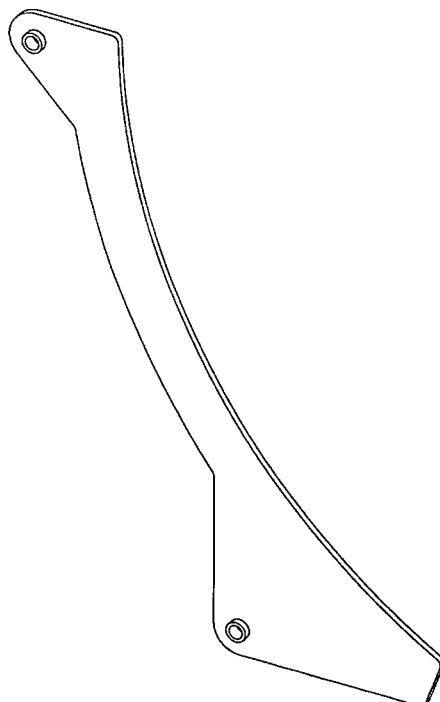
Measured by:	RB
Date:	9-4-29

<b>Audited by:</b>	
<b>Date:</b>	09/04/28

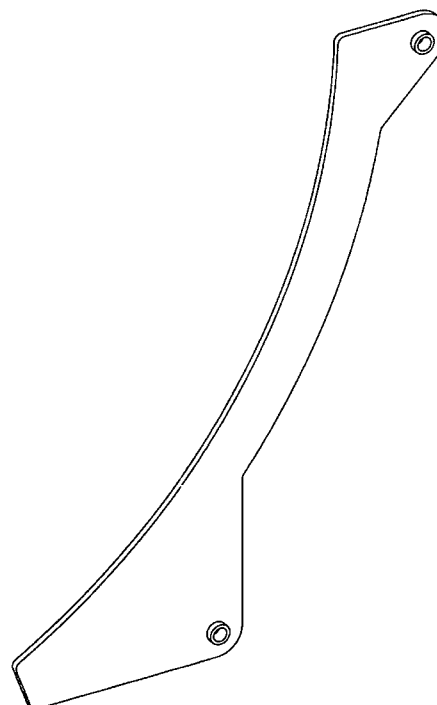
<b>Prototype Approval:</b>	1
<b>Date:</b>	7

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

ITEM	QTY -041	QTY -042	P/N	DESCRIPTION
1	X		D3929-041	GUSSET ASSEMBLY
2		X	D3929-042	GUSSET ASSEMBLY
11	2	2	D3907-1	BUSHING
12	1	1	D3929-1	SUPPORT GUSSET



**D3929-041 GUSSET ASSEMBLY**



**D3929-042 GUSSET ASSEMBLY**

*W/D 47558*

**RELEASED**  
*9/6/12 M/D*

- NOTES:**
- 1) MATERIAL: N/A
  - 2) FINISH: N/A
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3929-04X" USING FINE POINT PERMANENT INK MARKER
  - 7) WEIGHT: 0.73 lbs EACH
  - 8) WELDING: PER DART QSI 004

A	NEW ISSUE	MB	09.04.03
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	09.04.03		

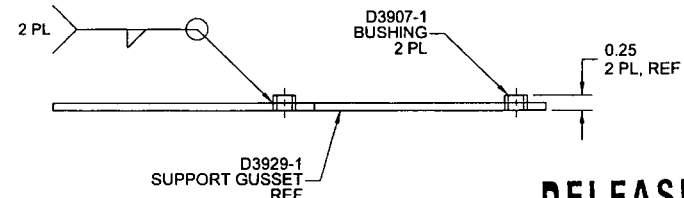
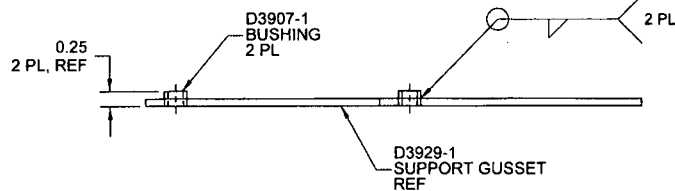
**DART AEROSPACE LTD**  
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3929** REV. A  
SHEET 1 OF 3  
TITLE **GUSSET ASSEMBLY** SCALE NTS

COPYRIGHT © 2009 BY DART AEROSPACE LTD  
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS  
NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT  
WRITTEN PERMISSION FROM DART AEROSPACE LTD

D3929-1  
SUPPORT GUSSET  
2 PL

D3929-1  
SUPPORT GUSSET  
2 PL



**D3929-041 GUSSET ASSEMBLY**

**D3929-042 GUSSET ASSEMBLY**

**RELEASED**  
09/04/22 AD

47558

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. <b>D3929</b>	REV. A
MFG. APPR.		SHEET 2 OF 3	
APPROVED		TITLE	SCALE
DE APPR.		<b>GUSSET ASSEMBLY</b>	NTS
DATE	<b>09.04.03</b>	<small>COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

